

# Work Order ID 63346

Wednesday, October 27, 2010 4:02:03 PM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 10/27/2010 Start Qty: 5.00

Required Date: 11/11/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
DSI 9467	Rev A
IIN D206-642	Rev N

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Create White labels per PPP K642-512 CHG004

8.10.10/02

for BG 10-11-12 @  
(white label only)

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			0 P e					

**NOTE:** Date & initial all entries

**Work Order ID 63346**

Wednesday, October 27, 2010 4:02:03 PM

Page 2

Item ID: K642-512

Accept

Revision ID:

Item Name: saddle kit 642-512

Setup Start

Stop

Start Date: 10/27/2010 Start Qty: 5.00

Required Date: 11/11/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

130

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location:

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



QC

Quality Control



Packaging

Packaging



QC

Quality Control

Dw 12/02

0.00

10 12 02 (2)

130

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location:

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

PK REVA

D's

10/12/25

10/12/03

NF 10-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	68.0000	3	156		10/11/10	
BOLT													

Location	Loc Qty	Loc Code
ST353	68	
109323	6	
111724	1	
112489	31	
114523	30	

AN3C36A		Purchased	No			110	Each	115.0000	9	45		10/11/10	
BOLT													

Location	Loc Qty	Loc Code
ST353	115	
109771	10	
115358	15	
115518	40	
115882	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			0					

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# Picklist Print

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Wednesday, October 27, 2010 4:02:07 PM

Work Order ID: 63346



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00 <sup>2</sup>

Required Qty: 5.00

AN3C41A

Purchased

No

110

Each

111.0000

8



BOLT



4016  
10/11/15 f

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

107

108084

7

108409

8

112879

1

114443

59

115316

32

10

AN4C6A

Purchased

No

110

Each

335.0000

12



Bolt



6029  
10/11/15 f (24)

Location

Loc Qty

Loc Code

FG

4

103344

4

ST

4

103344

0

111295

4

ST356

327

113121

127

115016

200

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: ~~5.00~~ 2

Required Qty: 5.00

AN5C11A

Purchased

No

110

Each

204.0000

8



Bolt



10/11/10

Location

Loc Qty

Loc Code

FG

4

104817

4

ST338

200

108428

8

109898

8

114443

14

114455

70

114523

100

AN5C12A

Purchased

No

110

Each

64.0000

4



10/11/10

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

62

113121

62

AN5C13A

Purchased

No

110

Each

82.0000

4



10/11/10

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

80

111648

1

113121

29

114615

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

AN5C15A

Purchased No

110

Each

81.0000

1

5



Bolt

Location

Loc Qty

Loc Code

ST339

81

~~111819~~

81

110

Each

90.0000

2

10

AN5C32A

Purchased No



Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

86

107013

1

107463

2

~~111808~~

33

113164

50

110

Each

104.0000

2

10

AN5C34A

Purchased No



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

102

107289

2

110342

2

111648

38

~~112454~~

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.002

Required Qty: 5.00

AN5C35A

Purchased

No

110

Each

93.0000

1



52  
10/11/155

Location

Loc Qty

Loc Code

ST340

93

107551

2

108084

45

108407

46

2

AN960C10L

NAS1149C0332  
R

Purchased

No

110

Each

29.0000

24



12048

washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C416L

Purchased

No

110

Each

164.0000

24



12048

WASHER

NAS1149C0432A

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

120

106785

10

107008

10

112612

3

112794

29

112828

27

69220

41

12048  
11/14/15 5/20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

AN960C516L NAS1149C0532 Purchased No

110 Each 22.0000 8



WASHER



M11531 10/11/10

Location	Loc Qty	Loc Code
ST347	22	
103344	8	
109545	8	
111916	6	

D206-648-013 Manufactured No

110 Each 2.0000 1



GHW Modification



B63329 10/11/10  
B60860 1x 10/11/10

Location	Loc Qty	Loc Code
FG120	2	
42315	1	
47600	1	

D2652 Manufactured No

110 Each 151.0000 16



Bushing



B63311 10/11/10

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST020	107	
61645	1	
62659	106	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

D2712

Manufactured No

110

Each

413.0000

10

50

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

363

61331

363

Manufactured No

110

Each

11.0000

1

5

D2932-2

Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

1

41440

1

ST428

10

52586

6

60253

4

Manufactured No

110

Each

1.0000

1

5

D2933-2

Saddle RH In, 206

Location

Loc Qty

Loc Code

ST428

1

41129

1

Manufactured No

110

Each

20.0000

2

10

D2934

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

14

59641

14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, October 27, 2010 4:02:07 PM

Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: ~~5.00~~ 2

Required Qty: 5.00

D2935

Manufactured No

110

Each

51.0000

2

Saddle Spacer

Location

Loc Qty

Loc Code

ST028

51

59642

6

62690

45

Manufactured No

110

Each

0.0000

1

D2938-2

Saddle RH Out, 206

D2939-2

Manufactured No

110

Each

1.0000

1

Saddle RH In, 206

Location

Loc Qty

Loc Code

ST428A

1

58268

1

Manufactured No

110

Each

31.0000

2

D3396-3

Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

21

36336

2

45667

2

58680

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

82-  
D3407-043



Tow Ring

Manufactured No

110

Each

15.0000

1

5



10/11/10

Location

Loc Qty

Loc Code

ST420

8

62627

8

ST464

7

50387

7

2

82-  
D3456-1



Washer

Manufactured No

110

Each

3.0000

1

5



B62239 10/11/10

Location

Loc Qty

Loc Code

ST058

3

54692

3

82-  
D3457-1



Washer

Manufactured No

110

Each

13.0000

2

10



B62239 10/11/10

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

3

45913

1

52981

2

82-  
D3672-1



Phenolic Washer

Manufactured No

110

Each

847.0000

24

120



10/11/10

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

20

28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, October 27, 2010 4:02:07 PM

Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: ~~5.00~~ 2

Required Qty: 5.00

D3672-3  
Phenolic Washer

Manufactured No

110 Each

559.0000 24 120

Location

Loc Qty

Loc Code

ST077

559

47023

16

55500

32

57704

511

D3672-7  
Phenolic Washer

Manufactured No

110 Each

556.0000 24 120

Location

Loc Qty

Loc Code

ST077

556

35522

8

51696

16

53237

532

MS21043-3  
Nut

Purchased No

110 Each

2,506.000 20

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2430

112314

2430

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, October 27, 2010 4:02:07 PM

Work Order ID: 63346

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 5.00

Required Qty: 5.00

MS21043-4

Purchased

No

110

Each

946.0000

13

65



Nut

## Location

## Loc Qty

## Loc Code

FG	40	
104603	40	
ST301	906	
112492	25	
113069	8	
114181	29	
114523	244	
114784	300	
115936	300	

MS21043-5

Purchased

No

110

Each

580.0000

4

20



Nut

## Location

## Loc Qty

## Loc Code

ST301	580	
111819	80	
112314	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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